

Date: Thursday, 12/13/2007 2:42:18 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	36337		
Estimate Number	12788		
P.O. Number	N/A	Part Number	D356413
This Issue	12/13/2007	S.O. No.	N/A
Prsh Rev.	NC	Drawing Number	D3564 REV D
First Issue	N/A	Project Number	N/A
Previous Run	33867	Drawing Revision	D
Written By		Material	N/A
Checked & Approved By		Due Date	12/21/2007
Comment	Qty: 20 Um: Each		
	Est Rev:A New Issue 07-03-08 ec		
	Est Rev:B As per Rev C 07-07-09 JLM		
	Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 3.927
	Comment: Qty.: 0.1785 sf(s)/Unit Total : 3.5700 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 105997 1B 07-12-14	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: P Prog Rev: D	1B 07-12-14 (22)
	2-Deburr if necessary	1B 07-12-14
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 1B 07-12-14
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	1B 07-12-14 (422) <i>counts</i>
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT	1B 07-12-14 (8179) 8155
		SB 08/01/09 (22)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 2:42:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 36337

Part Number: D356413

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

✓ 08/01/08 x22

7.0 POWDER COATING

POWDER COATING



M 106442



x22

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-f 08/01/10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



yQ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-10

x22

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP21

YJ 08-01-10

x22

10.0 QC21

FINAL INSPECTION/W/O RELEASE



x22

Comment: FINAL INSPECTION/W/O RELEASE

✓ 08/01/11

Job Completion



✓ 08-01-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Wearshoe	Part Number:	D3564-13
Inspection Dwg: D3564	Rev: <i>CD</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

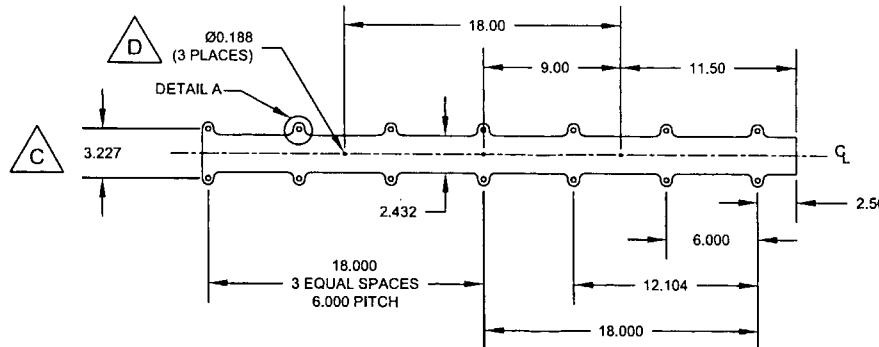
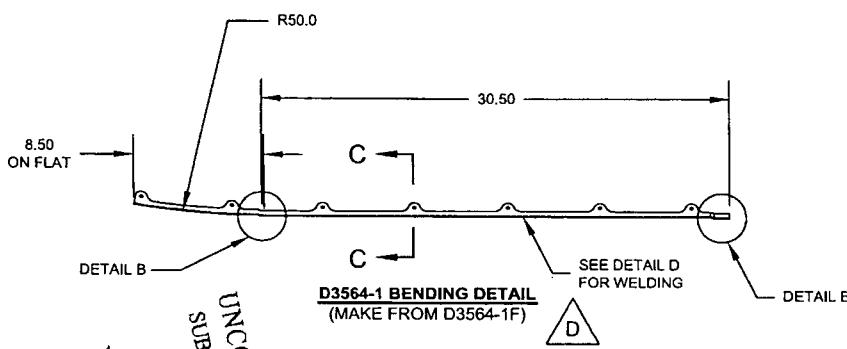
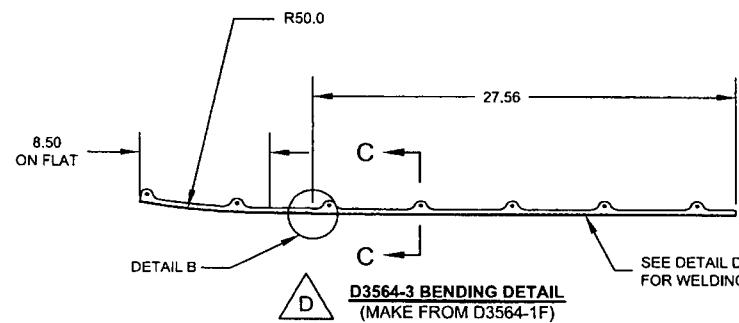
X First Article Prototype

07.12.14

Measured by:	<u>B</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	07-12-14	Date:	3/2/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. C	KJ/JLM	BE

8 7 6 5 4 3 2 1

**D3564-1F FLAT PATTERN**RELEASED
07.09.04**D3564-1 BENDING DETAIL**
(MAKE FROM D3564-1F)

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8; PG3 B5,C5 ADD D3564-15; PG1 B6,B3; D3564-1/11 WAS ONE FIGURE; PG2 A7,A3; D3564-9/11 WAS ONE FIGURE; PG2 A7,A3; D3564-9/11 WAS ON PG1; PG3 B8,C8; D3564-13 WAS ON PG2; PG3 D2; WELDING DETAIL WAS ON PG1 PG3 A5,7,B2; RELOCATE DETAILS AND SECTION; PG3 A5,7,B2; INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB	DRAWING NO.	REV. D
CHECKED	PH	D3564	SHEET 1 OF 3
MFG. APPR.	SI	APPROVED	SCALE
APPROVED	SI	DE APPR.	WEARSHOE
DE APPR.	SI	DATE	1:8
		07.08.21	

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D3564-1/3-5/7-9/11-13/15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT $\frac{1}{4}$

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WORK ORDER

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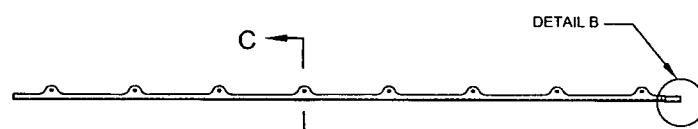
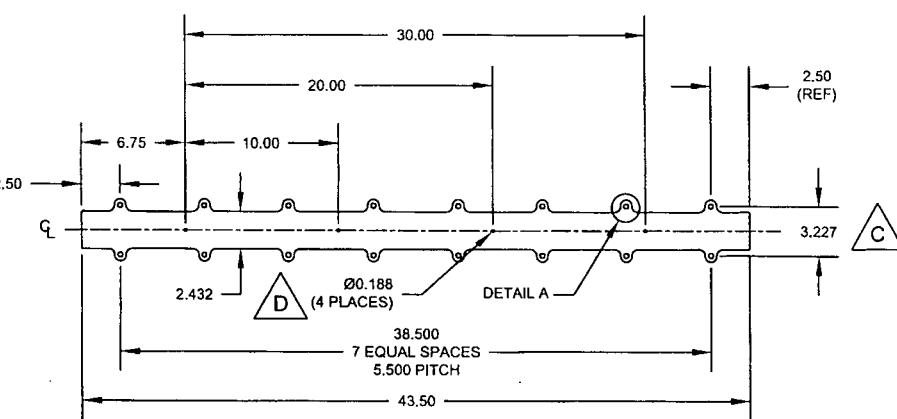
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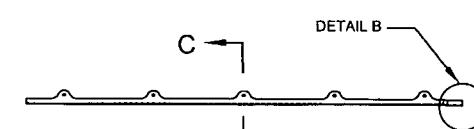
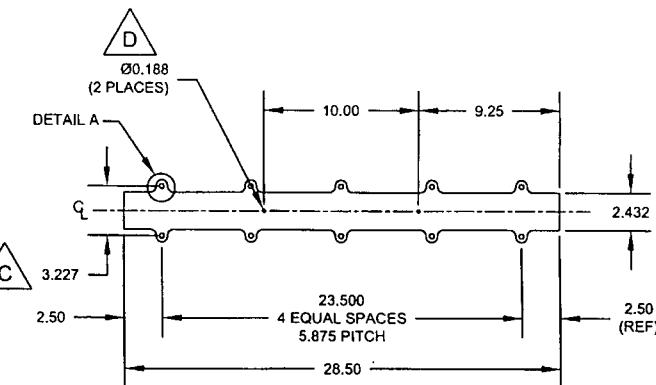
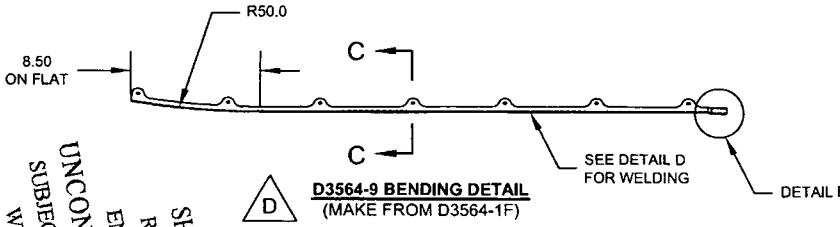
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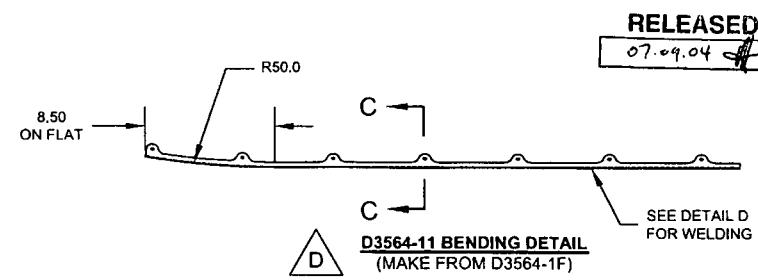
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D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



RELEASED
07-09-04

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DRAWN	C.B	HAWKSLEY, ONTARIO, CANADA
CHECKED	P4	REV. D
MFG. APPR.	SI	D3564
APPROVED	100	SHEET 2 OF 3
DE APPR.	SI	TITLE
DATE	07.08.21	SCALE
		WEARSHOE
		1:8
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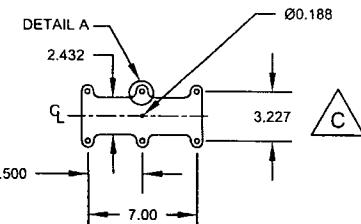
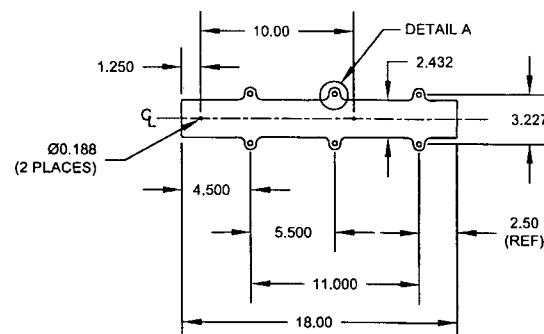
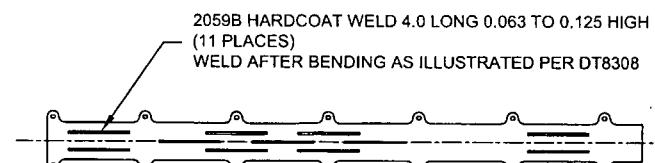
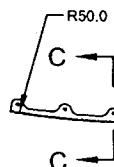
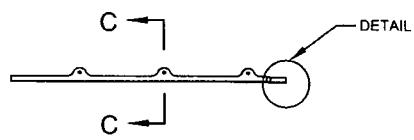
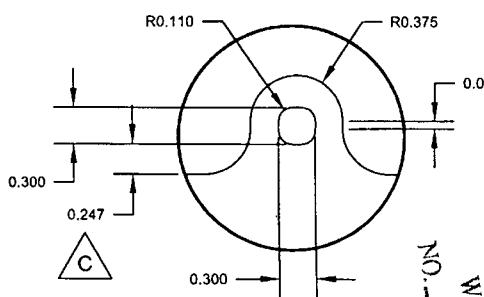
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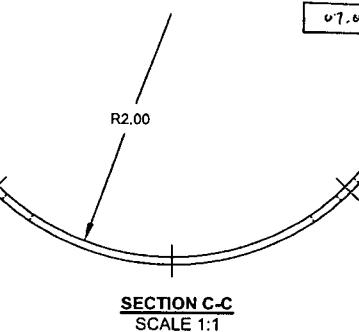
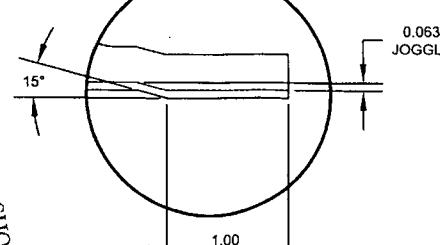
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D3564-13F FLAT PATTERND3564-15F FLAT PATTERNDETAIL D
(D3564-1/3-9/11 WELDING DETAIL)D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

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SECTION C-C
SCALE 1:1

DESIGN	P4	DART AEROSPACE LTD
DRAWN	C8	HAWKESBURY, ONTARIO, CANADA
CHECKED	P4	DRAWING NO. D3564
MFG. APPR.	AI	REV. D
APPROVED	MP	SHEET 3 OF 3
DE APPR.	MP	TITLE WEARSHOE
DATE	07.08.21	SCALE 1:8

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